

Date: Monday, 10/16/2006 2:02:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPRING CLIP ASSEMBLY
 Job Number : 29025
 Estimate Number : 10645
 P.O. Number : N/A Part Number : D2429041
 This Issue : 10/16/2006 S.O. No. : N/A Drawing Number : D2429 REV C1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C1
 Previous Run : 27523 Material : N/A
 Due Date : 10/30/2006 Qty: 40 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. D 02-03-06 Added note at step 7 NG
 Est Rev:E Now on Waterjet 06-06-13 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 0.0071 sf(s)/Unit Total: 0.1428 sf(s)

304/316 .040 Sheet

(M304S040) m 101264 ml 06 12 01

Batch: m 102159 ml 06 10 18

(40)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2429

Dwg Rev: C1

Prog Rev: C1

ml 06 10 18 ml 06 12 01

(40)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 12 01

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Joe 10-18 (20)
 count. 11/06/12/01 (20)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429

ml 06 10 18 (20)

SB 06 12 05 (20)

SB 06 11 21 05

40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/05	5.1	Add QCS to step 5.1 perm. chg.	E	06.12.05	(40)		AA 06/12/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 29025

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	M18491

SB 06/12/06

(20)

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	M5519

NOTE: 2 D2429-1 required for 1 assy.

SB 06/12/06

20

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SB 06/12/06

(20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/12/06

(20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST45

SB 06/12/07 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/12/08

(20)

Job Completion



U 06/12/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

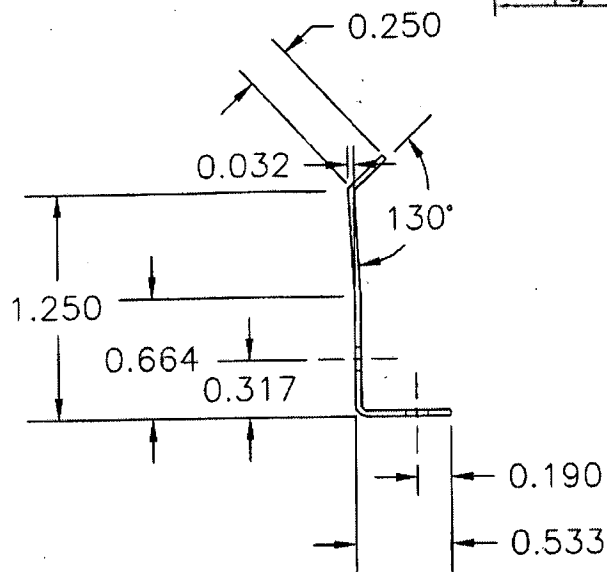
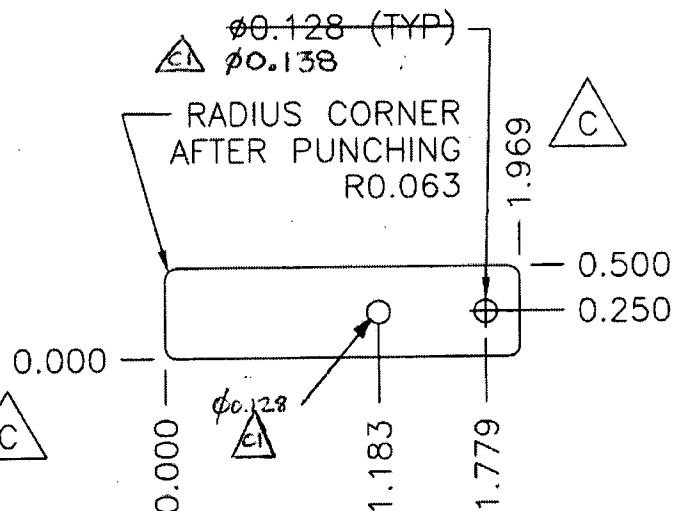
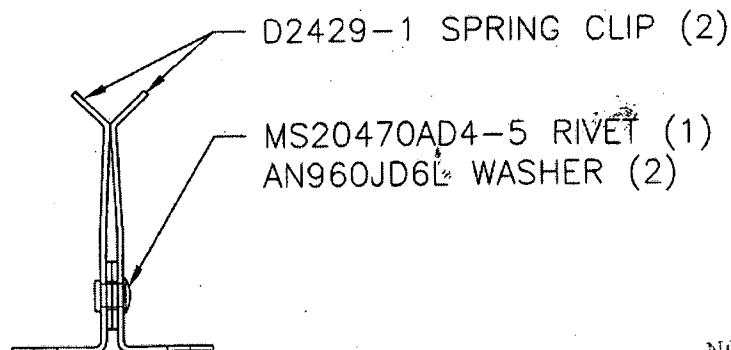
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	ø0.138 WAS ø0.128	

RELEASED
00.06.27 #D2429-1 SPRING CLIPD2429-1 FLAT PATTERND2429-041 SPRING CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29025

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

X	Prototype
----------	------------------

[illegible]

Measured by: <i>M. M.</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>06-10-18</i>	Date: <i>06-10-18</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	